



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4292-1

Job Sheet 167873



Part No: D4292-1

Job Qty: 6 ea

Part Name: Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/7/17

Job Tracking No:

Due Date: 12/8/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Heliswiss Iberica SA (CHELI02)

Hangar 4, Lado Norte, Aeropuerto De Sabadell, Barcelona Sabadell, , 08205 Spain ph:011 34 93 720 6090
fx:34-937-100130.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	12/7/17	12/7/17	0.00	0.00	Start Up Machining		<i>mk</i> 12-12-20
100	Bandsaw	6 pcs	12/7/17	12/7/17	0.00	0.51	Bandsaw1		<i>mk</i> 12-12-20
110	CNC Vertical Machining	6 pcs	12/7/17	12/7/17	0.51	12.34	HAAS 5 Axis		<i>mk</i> 12-12-21
120	QC	6 pcs	12/7/17	12/7/17	0.00	0.00	QC2		<i>mk</i> 12-12-21
130	QC	6 pcs	12/7/17	12/7/17	0.00	0.00	QC8		<i>mk</i> 12-12-21
140	HandFinish	6 pcs	12/7/17	12/7/17	0.00	0.34	HandFinish1		<i>mk</i> 12-12-21
145	Powdercoat	6 pcs	12/7/17	12/7/17	0.00	0.45	Powdercoat1		<i>mk</i> 12-12-21
150	QC	6 pcs	12/7/17	12/7/17	0.00	0.00	QC3		<i>mk</i> 12-12-21
151	Small Fab	6 pcs	12/8/17	12/8/17	0.00	0.27	Small Fab		<i>mk</i> 12-12-21
152	QC	6 pcs	12/8/17	12/8/17	0.00	0.00	QC5		<i>mk</i> 12-12-21
180	Packaging	6 pcs	12/8/17	12/8/17	0.00	0.00	Packaging3		<i>mk</i> 12-12-21
190	QC21-SA	6 Ea	12/8/17	12/8/17	0.00	0.00	QC21		<i>mk</i> 12-12-21

Part Op 100 - Cut Blank to 6.250" ****GRAIN DIRECTION MUST BE ALONG 4.00"*****

Descriptions: 110 - 1-Machine per folio FB002

145 - MASK THREADED HOLE

151 - INSTAL HELICOIL

DAS
21
9-09

JAN 09 2016

mk 138467 START: 8:40 O.V.T. 320° FINISH: 9:10.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T73B4.000x4.000	3	7	0	0
151-Small Fab	MS21209F1-10	6	27	0	0

FM137951-5

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.063Inches ± 0.010	0.073 0.053	csk	
2	Fitting	0.250Inches + 0.030 - 0.010	0.280 0.240		
3	Fitting	0.125Inches + 0.030 - 0.010	0.155 0.115		
4	Fitting	2.950Inches ± 0.030	2.980 2.920		

SD17358 x4 SD17358

DART
AEROSPACE
S025682

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Fitting

PART NO: D4292-1

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/20/17

Job No: 167873

5	Fitting	0.275Inches $\pm$ 0.010	0.285 0.265	
6	Fitting	0.800Inches $\pm$ 0.010	0.810 0.790	
7	Fitting	0.825Inches $\pm$ 0.010	0.835 0.815	
8	Fitting	0.375Inches $\pm$ 0.010	0.385 0.365	
9	Fitting	0.310Inches $\pm$ 0.030	0.340 0.280	
10	Fitting	0.880Inches $\pm$ 0.030	0.910 0.850	
11	Fitting	0.663Inches $\pm$ 0.010	0.673 0.653	
12	Fitting	0.381Inches + 0.000 - 0.001	0.381 0.380	
13	Fitting	1.125Inches $\pm$ 0.010	1.135 1.115	
14	Fitting	1.063Inches $\pm$ 0.010	1.073 1.053	
15	Fitting	3.440Inches $\pm$ 0.030	3.470 3.410	
16	Fitting	2.450Inches $\pm$ 0.010	2.460 2.440	
17	Fitting	1.325Inches $\pm$ 0.010	1.335 1.315	
18	Fitting	0.300Inches $\pm$ 0.010	0.310 0.290	
19	Fitting	1.200Inches $\pm$ 0.010	1.210 1.190	
20	Fitting	2.840Inches $\pm$ 0.030	2.870 2.810	
21	Fitting	0.190Inches $\pm$ 0.030	0.220 0.160	
22	Fitting	5.860Inches $\pm$ 0.030	5.890 5.830	
23	Fitting	5.990Inches $\pm$ 0.030	6.020 5.960	
24	Fitting	0.272Inches + 0.006 - 0.001	0.278 0.271	
25	Fitting	0.266Inches + 0.006 - 0.001	0.272 0.265	
26	Fitting	1.750Inches $\pm$ 0.030	1.780 1.720	
27	Fitting	0.250Inches $\pm$ 0.030	0.280 0.220	Radius
28	Fitting	0.060Inches $\pm$ 0.030	0.090 0.030	Radius
29	Fitting	4.875Inches $\pm$ 0.010	4.885 4.865	
30	Fitting	0.493Inches $\pm$ 0.010	0.503 0.483	
31	Fitting	0.765Inches $\pm$ 0.010	0.775 0.755	c-bore
32	Fitting	0.250Inches + 0.030 - 0.010	0.280 0.240	
33	Fitting	0.680Inches $\pm$ 0.010	0.690 0.670	
34	Fitting	2.250Inches $\pm$ 0.010	2.260 2.240	
35	Fitting	4.500Inches $\pm$ 0.010	4.510 4.490	
36	Fitting	1.275Inches $\pm$ 0.010	1.285 1.265	
37	Fitting	0.031Inches $\pm$ 0.010	0.041 0.021	Radius

38	Fitting	0.130Inches $\pm$ 0.030	0.160 0.100	Radius
39	Fitting	1.650Inches $\pm$ 0.030	1.680 1.620	
40	Fitting	1.421Inches $\pm$ 0.010	1.431 1.411	

Plex 11/7/17 2:16 PM dart.poulin.mario

DART AEROSPACE LTD		Work Order:	167873
Description: Fitting		Part Number:	D4292-1
Inspection Dwg: D4292 Rev: C		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/-0.010	.0625	✓		Rad gauge	
0.250	+0.030/-0.010	.246	✓		SLIO	vern
0.125	+0.030/-0.010	.123	✓			
2.95	+/-0.030	2.944	✓			
0.275	+/-0.010	.272	✓			
0.800	+/-0.010	.801	✓			
0.825	+/-0.010	.825	✓			
0.375	+/-0.010	.372	✓			
0.31	+/-0.030	.314	✓			
0.88	+/-0.030	.866	✓			
0.663	+/-0.010	.659	✓			
Ø0.381	+0.000/-0.001	.380	✓			
1.125	+/-0.010	1.125	✓			
1.063	+/-0.010	1.063	✓			
3.44	+/-0.030	3.435	✓			
2.450	+/-0.010	2.450	✓			
1.325	+/-0.010	1.323	✓			
0.300	+/-0.010	.298	✓			
1.200	+/-0.010	1.200	✓			
2.84	+/-0.030	2.838	✓			
0.19	+/-0.030	.185	✓			
5.86	+/-0.030	5.860	✓			
5.99	+/-0.030	5.988	✓			
Ø0.272	+0.006/-0.001	.273	✓			
Ø0.266	+0.006/-0.001	.266	✓			
1.75	+/-0.030	1.751	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
R0.06	+/-0.030	R.060	✓		"	
4.875	+/-0.010	4.875	✓		SLIO	vern
0.493	+/-0.010	.491	✓			
C-bore Ø0.765	+/-0.010	.765	✓			
0.250	+0.030/-0.010	.252	✓			
0.680	+/-0.010	.680	✓			
2.250	+/-0.010	2.250	✓			
4.500	+/-0.010	4.500	✓			
R1.275	+/-0.010	1.275	✓		Rad gauge	
R0.031	+/-0.010	.031	✓		SLIO	vern

